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D3009-3

Job Sheet 186488



Part No: D3009-3

Job Qty: 30 ea

Part Name: Cup



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/16/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP A 07.12.18 new issue EC IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		11/30/18	0.00	0.00	Start Up Machining-1		11/18/18 JBD 11/11/18
100	Hardinge	30 pcs		11/30/18	0.00	3.55	Hardinge		11/18/18 JBD 11/11/18
120	QC	30 pcs		11/30/18	0.00	0.00	QC8		11/18/18 JBD 11/11/18
130	Packaging	30 pcs		11/30/18	0.00	0.00	Packaging3-1		11/18/18 JBD 11/11/18
140	QC21-SA	30 Ea		11/30/18	0.00	0.00	QC21		11/18/18 JBD 11/11/18

Part Op 100 - 1-TURN AS PER FOLIO FA130 & DWG D3009

Descriptions: 130 - *****STOCK IN LARGE FAB***** LOCATION WA002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	1.4370 fl (1.0470 ea)	90-Start up Operation	5130934

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304R1.000	1	45	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	
2	Cup	0.750Inches + 0.008 - 0.001	0.758 0.749	Diameter	
3	Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
4	Cup	0.062Inches ± 0.010	0.072 0.052	Radius	
5	Cup	0.094Inches ± 0.010	0.104 0.084		
6	Cup	0.353Inches ± 0.010	0.363 0.343		
7	Cup	0.063Inches ± 0.010	0.073 0.053		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

8	Cup	0.032Inches ± 0.010	0.042 0.022	Radius
9	Cup	45.000Degrees ± 0.000	45.000 45.000	Angle

Plex 11/16/18 10:02 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		
Date : _____		Step #: _____				MRB (QSI042) Approval	
Description Work Order						Completed By	
 Container No: S130934 Part: D3009-3 Job No: 186488 Serial No/Batch: S130934 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/23/18						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Root Cause							
Environment ☐	No Re-verification ☐						
Design ☐	Operator ☐						
Doc/Data ☐	Offset/Setup ☐						
Equip/Tooling ☐	Supplier ☐						
Handling/Pre ☐	Training ☐						
Material ☐	Use for Testing ☐						
Internal Transport ☐	Poor Information ☐						
Tribal Knowledge ☐	Rushing ☐						
LOA ☐	Product Improvement ☐						
Substation ☐	Process Improvement ☐						
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐						
OTHER : _____							